

# Work Order ID 80656

March-08-12 8:59:09 AM

**\*80656\***

Page 1

Item ID: D4434-047

Revision ID: ~~PRELIM~~

Item Name: Cover Assembly

Start Date: 2/24/12 Start Qty: 10.00

Required Date: 3/15/12 Req'd Qty: 10.00

Reference:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

**\*NR1\***

**\*NR2\***

**\*N900040100\***

Setup Start

**\*NS1\***

Stop

**\*NS2\***

Cust Item ID:

Customer:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4434

B

100

0.00

**\*100\***

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut D4434-7 as per Dwg

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*110\***

QC

Memo

0.00

Quality Control

B12-3-8

(10)

B12-3-8

# Work Order ID 80656

March-08-12 8:59:09 AM

**\*80656\***

Page 2

Item ID: D4434-047  
Revision ID: PRELIM  
Item Name: Cover Assembly

Accept

**\*N900040100\***

Setup Start **\*NS1\***  
Stop **\*NS2\***

Start Date: 2/24/12 Start Qty: 10.00 **\*10\***  
Required Date: 3/15/12 Req'd Qty: 10.00 **\*10\***  
Reference:

Cust Item ID:  
Customer:

Approvals: Process Plan: Date:  
QC: Date:

Tooling: Date:  
SPC (Y/N): Date:

Run Start **\*NR1\***  
Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00

**\*120\***

QC

Memo

0.00

Quality Control

Sc 12/03/09

(40)

130

Bend as per dwg

0.00

**\*130\***

Brake NC

Memo

0.00

Brake NC

Sc 12/03/16

(9)

pro ~~12/03/08~~

140

Bend as per dwg

0.00

**\*140\***

Small Fab

Memo

0.00

Small Fab

Sc 12/03/16

(9)

Transfer drill hole as per dwg

W/O:		80056 WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4434-012 PAR #: \_\_\_\_\_ Fault Category: Small FAB NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: Scrap Disposition: Scrap QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/03/16	130	1 piece Scrap because crack when bend R.C process	S 12/03/16 052042	Scrap & destroy no replace	S 12/03/16	S 12/03/16	S 052042 12/03/16	S 12/03/16

NOTE: Date & initial all entries

**Work Order ID 80656****\*80656\***

Page 3

Item ID: D4434-047

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID: PRELIM

Stop **\*NS2\***

Item Name: Cover Assembly

Start Date: 2/24/12 Start Qty: 10.00

**\*10\***

Cust Item ID:

Required Date: 3/15/12 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC5- Inspect part completeness to step on W/O

0.00

**\*150\***

QC

Memo

0.00

Quality Control

160

Chemical Conversion Coat per QSI005 4.1

0.00

**\*160\***

HandFinish

Memo

0.00

Hand Finishing

170

QC3- Inspect Part Finish

0.00

**\*170\***

QC

Memo

0.00

Quality Control

⑨ 7/6 12-3-20

9x Ø M-L 12/03/20

# Work Order ID 80656

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**\*80656\***

Page 4

Item ID: D4434-047  
Revision ID: PRELIM  
Item Name: Cover Assembly

Accept

**\*N900040100\***

Setup Start **\*NS1\***  
Stop **\*NS2\***

Start Date: 2/24/12 Start Qty: 10.00 **\*10\***  
Required Date: 3/15/12 Req'd Qty: 10.00 **\*10\***

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:  
QC: Date:

Run Start **\*NR1\***  
Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

180

**\*180\***

Small Fab

Small Fab

Memo

Install rivet as per dwg

0.00

0.00

185

**\*185\***

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

186

**\*186\***

Powdercoat

Powder Coating

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

2h10  
370°F  
2h40

0.00

0.00

m115128

SP12/03/21 (9)

SB 12/03/21 (9)

9 ~~SB~~ (2P) 12/03/22

# Work Order ID 80656

March-08-12 8:59:09 AM

**\*80656\***

Page 5

Item ID: D4434-047  
Revision ID: PRELIM  
Item Name: Cover Assembly

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Stop **\*NS2\***

Start Date: 2/24/12 Start Qty: 10.00 **\*10\***  
Required Date: 3/15/12 Req'd Qty: 10.00 **\*10\***

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:  
QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

187

QC3- Inspect Part Finish

0.00

**\*187\***

QC

Memo

0.00

Quality Control

*Handwritten: 12/03/22 (10)*

190

Identify as per dwg & Stock Location: 441

0.00

**\*190\***

Packaging

Memo

0.00

Packaging

*Handwritten: 12/03/22 (5)*

200

QC21- Final Inspection - Work Order Release

0.00

**\*200\***

QC

Memo

0.00

Quality Control

*Handwritten: 12/3/29*

*Handwritten: 12-03-29*

# Picklist Print

March-08-12 8:59:08 AM

Page 1

Work Order ID: 80656  
Parent Item: D4434-047  
Parent Item Name: Cover Assembly

Start Date: 2/24/12  
Start Qty: 10.00

Required Date: 3/15/12  
Required Qty: 10.00

Comments: IPP revA 11.10.06 new issue EC verified by:DD IPP RevB 11.12.22 per PA5  
EC verified by:JLM IPP RevC 12.01.24 PER DWG REV.A DD VERF:EC  
IPP RevD 12.03.05 per REV.B DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.040 6061-T6 .040 Sheet		Purchased	No			100	sf	274.8670	0.5789	6.0936842			

Location	Loc Qty	Loc Code
MAT021	274.867	
117653	27.91	
120154	72.5	
120218	174.457	

B2-3-8

MS20470AD4-8  
Rivet - Universal Head

12.03.21  
051042

Purchased No

185 Each 5,874.0000 2 20

Location	Loc Qty	Loc Code
Mezz	5874	
1642	1240	
2193	4634	

(10) 12/03/21  
M120578 (18x)

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 8068
<b>Description:</b> Bracket		<b>Part Number:</b> D4434-7
<b>Inspection Dwg:</b> D4434	<b>Rev:</b> A B	<b>Page 1 of 1</b>

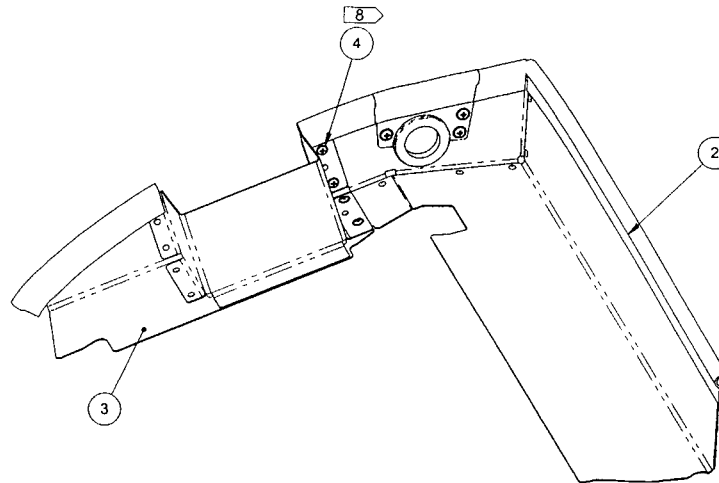
### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	101	2		V 1302	
1.42	+/-0.030	1.416	2		V	
1.70	+/-0.030	1.697	2		V	
2.24	+/-0.030	2.237	2		V	
3.81	+/-0.030	3.811	2		V	
10.41	+/-0.030	10.41	2		V 1301	
11.98	+/-0.030	11.98	2		T	
12.52	+/-0.030	12.52	2		T	
12.80	+/-0.030	12.80	2		T	
14.22	+/-0.030	14.22	2		T	
0.35	+/-0.030	0.356	2		V	
0.85	+/-0.030	0.859	2		V	
1.75	+/-0.030	1.748	1		V	
2.65	+/-0.030	2.666	2		V	
2.95	+/-0.030	2.954	2		V	
5.53	+/-0.030	5.53	2		V	
5.82	+/-0.030	5.819	2		V	
6.13	+/-0.030	6.13	2		V	
5.02	+/-0.030	5.02	2		V	
5.36	+/-0.030	5.366	2		V	
5.64	+/-0.030	5.64	2		V	
2.34	+/-0.030	2.340	2		V	
2.65	+/-0.030	2.650	2		V	
3.02	+/-0.030	3.020	2		V	
11.24	+/-0.030	11.24	2		T	
11.59	+/-0.030	11.59	2		T	
11.94	+/-0.030	11.94	2		T	
0.040	+/-0.010	0.039	2		V	

<b>Measured by:</b> B	<b>Audited by:</b> S	<b>Preliminary Approval:</b>
<b>Date:</b> 12-3-8	<b>Date:</b> 17/03/00	<b>Date:</b>
<b>Rev</b>	<b>Date</b>	<b>Change</b>
A	12.02.01	New Issue
		<b>Revised by</b> KJ
		<b>Approved</b>



ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D4434-041	FWD BRACKET ASSEMBLY
2	1	D4434-043	FWD INBOARD BRACKET ASSEMBLY
3	1	D4434-045	FWD OUTBOARD BRACKET ASSEMBLY
4	4	AN525-832R7	SCREW



*also 80656*

RELEASED  
R 2012-05-02  
JW

# **D4434-041 FWD BRACKET ASSEMBLY**

## **NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.43 lbs
- 8) TORQUE SCREW TO 12-15 (in-lb)

B	RE-DESIGN D4434-9/-9F (ZN B5-14, A5-15)	RF	12.02.22
A	NEW ISSUE	RF	12.01.17
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>MP</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>BE</i>	<b>D4434</b>	SHEET 1 OF 15
APPROVED	<i>MP</i>	TITLE	SCALE
DE APPR.	<i>MP</i>	<b>COVER ASSEMBLY</b>	NTS
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8

7

6

5

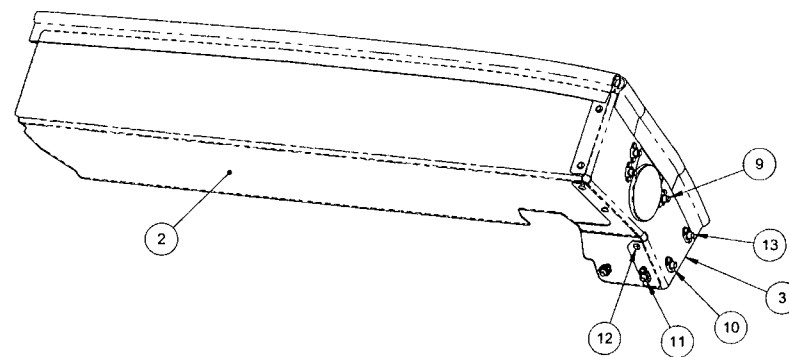
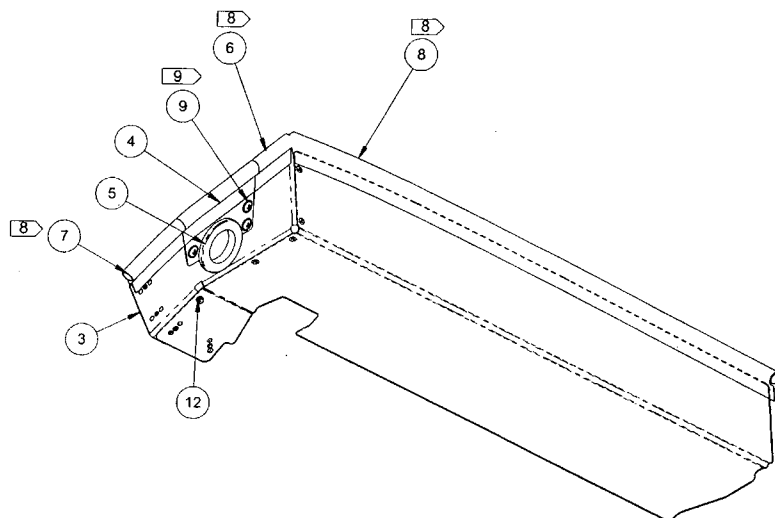
4

3

2

1

ITEM	QTY -043	PART NUMBER	DESCRIPTION
1	X	D4434-043	FWD INBOARD BRACKET ASSEMBLY
2	1	D4434-1	BRACKET
3	1	D4434-9	BRACKET
4	1	D4435-041	BRACKET ASSEMBLY
5	1	D4440-1	GROMMET
6	1	D4441-1-017	RUBBER SEAL
7	1	D4441-1-025	RUBBER SEAL
8	1	D4441-1-225	RUBBER SEAL
9	3	AN525-832R6	SCREW
10	12	MS20426AD3-2	RIVET
11	2	MS20426AD3-3	RIVET
12	5	MS20470AD4-3	RIVET
13	7	MS21075L08	NUT PLATE
14	A/R	3M 1300/1300L	ADHESIVE



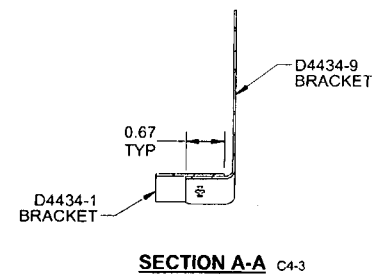
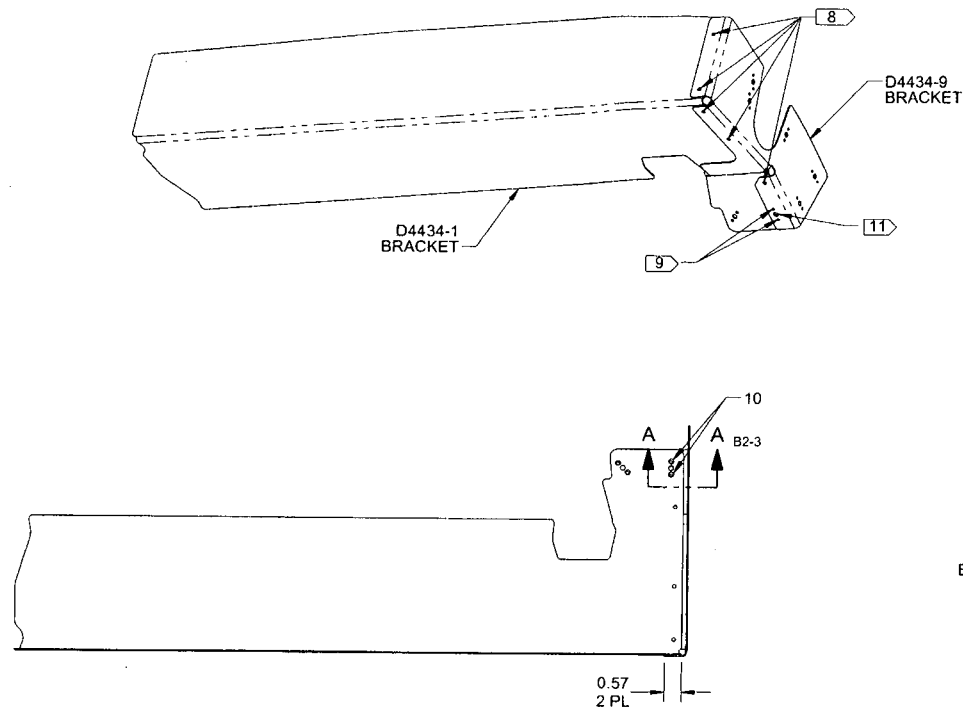
RELEASED  
2012-03-02

# **D4434-043 FWD INBOARD BRACKET ASSEMBLY**

## **NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK SANDEXT" (4.3.5.7) PER DART QSI 005 4.3  
MASK NUT PLATE HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.05 lbs
- 8) INSTALL RUBBER SEAL TO EDGE OF PART AFTER POWDER COAT USING 3M 1300/1300L ADHESIVE  
ENSURE BRACKET IS COMPLETELY INSERTED INTO GROOVE OF RUBBER SEAL  
IT IS ACCEPTABLE TO NOTCH THE SEAL AS REQUIRED TO PREVENT IT FROM BUCKLING
- 9) TORQUE SCREW TO 12-15 (in-lb)

DESIGN	RF	<b>DART AEROSPACE LTD.</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>MP</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>BE</i>	<b>D4434</b>	SHEET 2 OF 15
APPROVED	<i>MP</i>	TITLE	SCALE
DE APPR.	<i>MP</i>	<b>COVER ASSEMBLY</b>	NTS
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# NOTES:

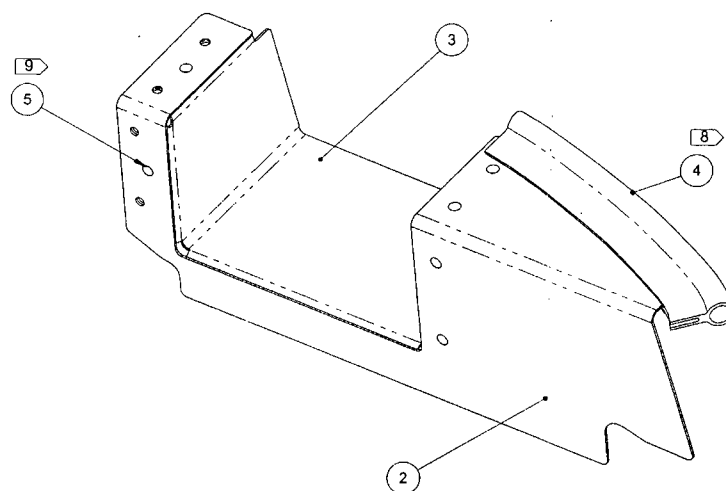
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.05 lbs
- 8) TRANSFER  $\phi 0.129$  HOLES THRU 5 PLACES FROM D4434-9 TO D4434-1
- 9) TRANSFER  $\phi 0.098$  HOLES THRU 2 PLACES FROM D4434-9 TO D4434-1
- 10) CSK  $\phi 0.179 \times 100^\circ$  ON THIS SIDE 2 PLACES
- 11) TRANSFER  $\phi 0.177$  HOLE THRU FROM D4434-9 TO D4434-1

## **D4434-043 FWD INBOARD BRACKET ASSEMBLY** AUXILIARY VIEW

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>MP</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>BE</i>	<b>D4434</b>	SHEET 3 OF 15
APPROVED	<i>MP</i>	TITLE	SCALE
DE APPR.	<i>#</i>	<b>COVER ASSEMBLY</b>	NTS
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RELEASED  
2012-03-02

ITEM	QTY -045	PART NUMBER	DESCRIPTION
1	X	D4434-045	FWD OUTBOARD BRACKET ASSEMBLY
2	1	D4434-3	BRACKET
3	1	D4434-5	BRACKET
4	1	D4441-1-060	RUBBER SEAL
5	6	MS20426AD4-4	RIVET



**D4434-045 FWD OUTBOARD BRACKET ASSEMBLY**

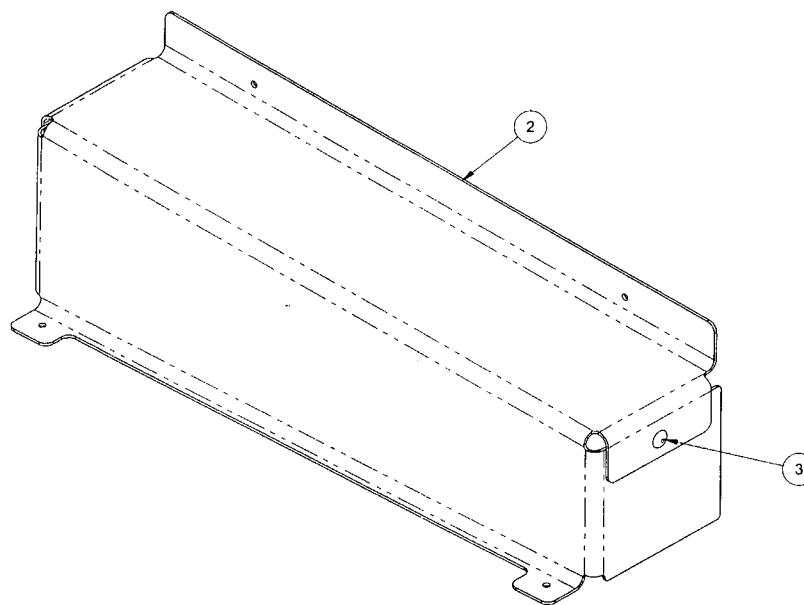
RELEASED  
2012-03-02

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK SANDEX" (4.3.5.7) PER DART QSI 005 4.3  
MASK NUT PLATE HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.365 lbs
- 8) INSTALL RUBBER SEAL TO EDGE OF PART AFTER POWDER COAT USING 3M 1300/1300L ADHESIVE  
ENSURE BRACKET IS COMPLETELY INSERTED INTO GROOVE OF RUBBER SEAL  
IT IS ACCEPTABLE TO NOTCH THE SEAL AS REQUIRED TO PREVENT IT FROM BUCKLING
- 9) TRANSFER  $\varnothing 0.129$  HOLE 6 PLACES AND CSK TO  $\varnothing 0.225 \times 100^\circ$

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>RF</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>EE</i>	D4434	SHEET 4 OF 15
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	COVER ASSEMBLY	NTS
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ITEM	QTY -047	PART NUMBER	DESCRIPTION
1	X	D4434-047	COVER ASSEMBLY
2	1	D4434-7	BRACKET
3	2	MS20470AD4-3	RIVET



**D4434-047 COVER ASSEMBLY**

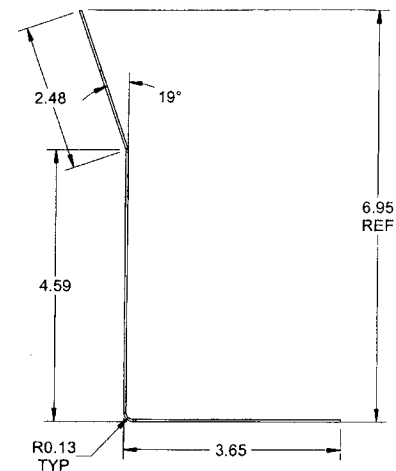
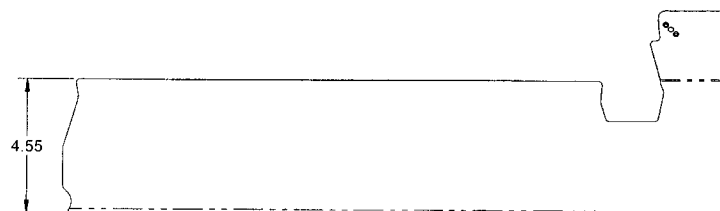
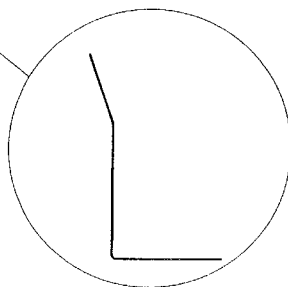
**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK SANTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.263 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>MP</i>	DRAWING NO. <b>D4434</b>	REV. B
MFG. APPR.	<i>BE</i>		SHEET 5 OF 15
APPROVED	<i>MP</i>	TITLE	SCALE
DE APPR.	<i>MP</i>	<b>COVER ASSEMBLY</b>	NTS
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**RELEASED**  
2012-03-02  
*MM*

B  
B2-6



**DETAIL B** C8-6  
SCALE 2X

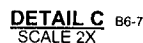
**D4434-1 BRACKET**

**NOTES:**

- 1) MATERIAL: MAKE FROM D4434-1F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.70 lbs

**RELEASED**  
2012-03-02

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>MP</i>	DRAWING NO. <b>D4434</b>	REV. B
MFG. APPR.	<i>BE</i>		SHEET 6 OF 15
APPROVED	<i>MP</i>	TITLE <b>COVER ASSEMBLY</b>	SCALE NTS
DE APPR.	<i>MP</i>	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DATE	12.02.22		

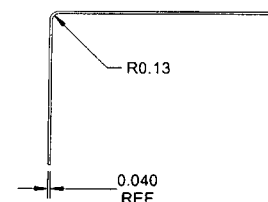
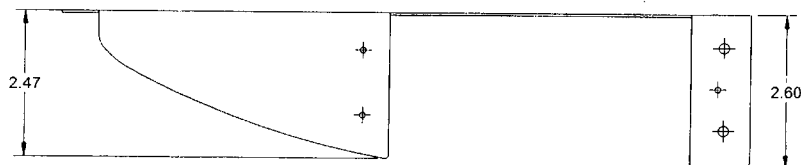
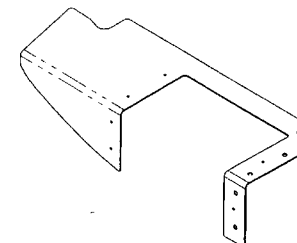
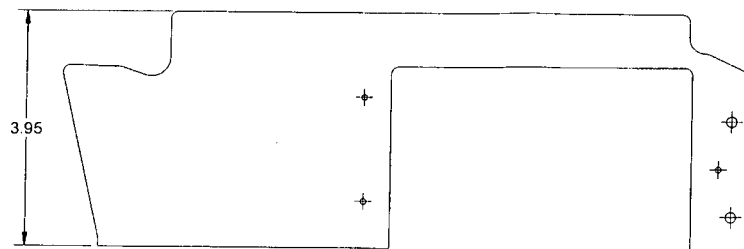


RELEASE  
2012-03-02

1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027  
OR ASTM B209  
REF DART SPEC. M6061T6S.040

- 2) FINISH: N/A  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: N/A  
7) WEIGHT: 0.70 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA  DRAWING NO. <b>D4434</b>  TITLE <b>COVER ASSEMBLY</b>  COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXCLUSIVE CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	REV. _____
DRAWN	RF		SHEET 7 OF _____
CHECKED	<i>RF</i>		SCALE _____
MFG. APPR.	<i>RF</i>		NT _____
APPROVED	<i>RF</i>		
DE APPR.	<del>RF</del>		
DATE <b>12.02.22</b>			



# **D4434-3 BRACKET**

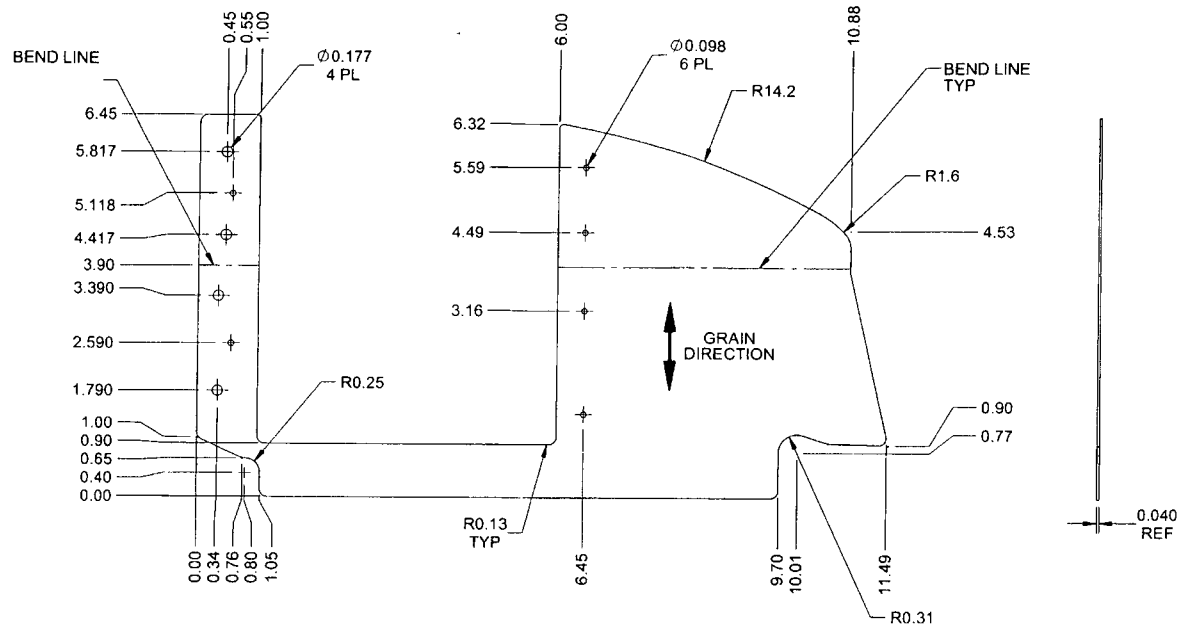
## **NOTES:**

- 1) MATERIAL: MAKE FROM D4434-3F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.14 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	<b>D4434</b>	SHEET 8 OF 15
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>COVER ASSEMBLY</b>	NTS
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2012-03-02  
JMM





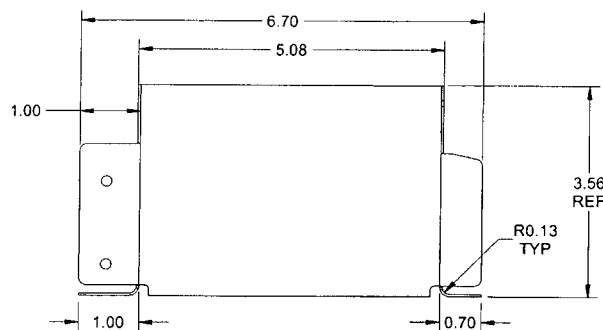
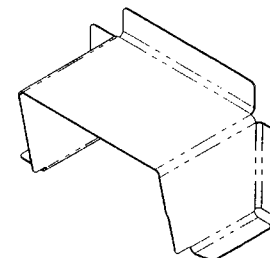
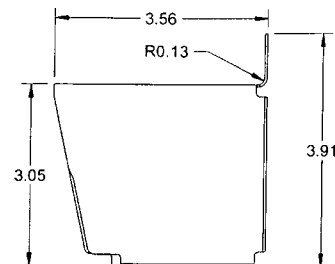
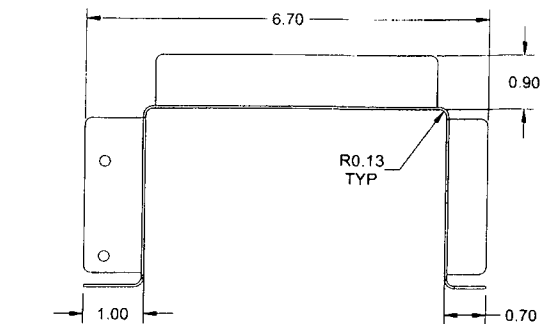
# **D4434-3F FLAT PATTERN**

## **NOTES:**

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027  
OR ASTM B209  
REF DART SPEC. M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.14 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>RF</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>RF</i>	<b>D4434</b>	SHEET 9 OF 15
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	<b>COVER ASSEMBLY</b>	NTS
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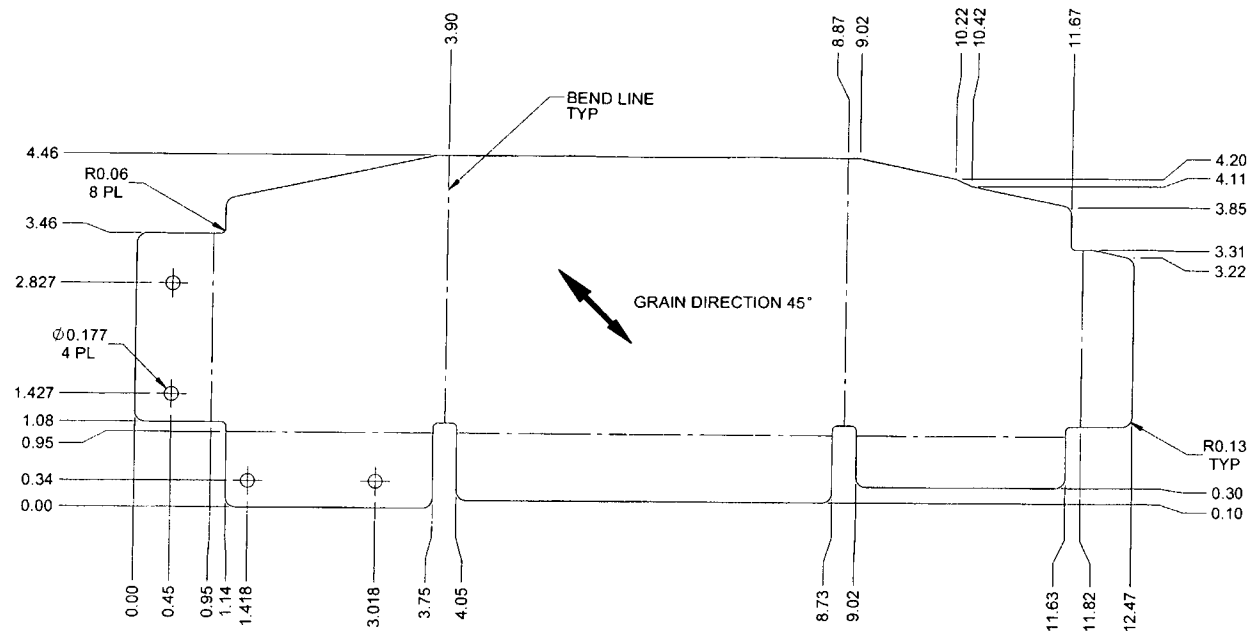
**D4434-5 BRACKET**

**NOTES:**

- 1) MATERIAL: MAKE FROM D4434-5F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.19 lbs

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DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>MP</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>BE</i>	<b>D4434</b>	SHEET 10 OF 15
APPROVED	<i>MP</i>	TITLE	SCALE
DE APPR.	<i>MP</i>	<b>COVER ASSEMBLY</b>	NTS
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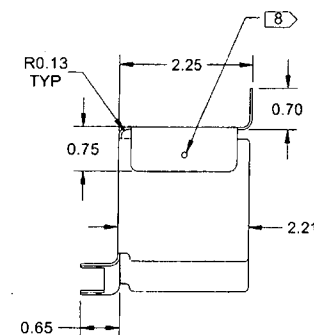
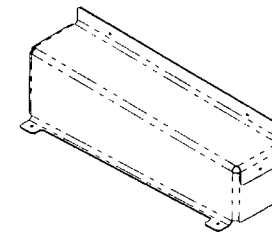
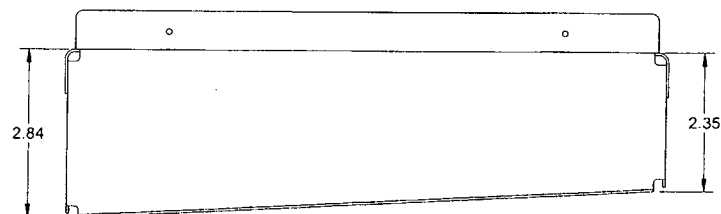
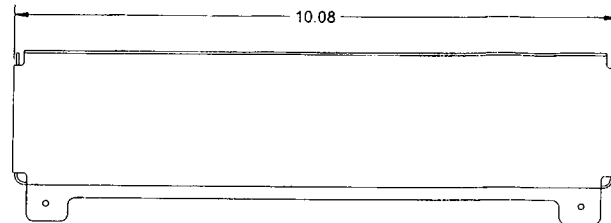
# **D4434-5F FLAT PATTERN**

## **NOTES:**

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027  
OR ASTM B209  
REF DART SPEC. M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.19 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>MP</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>BE</i>	<b>D4434</b>	SHEET 11 OF 15
APPROVED	<i>MP</i>	TITLE	SCALE
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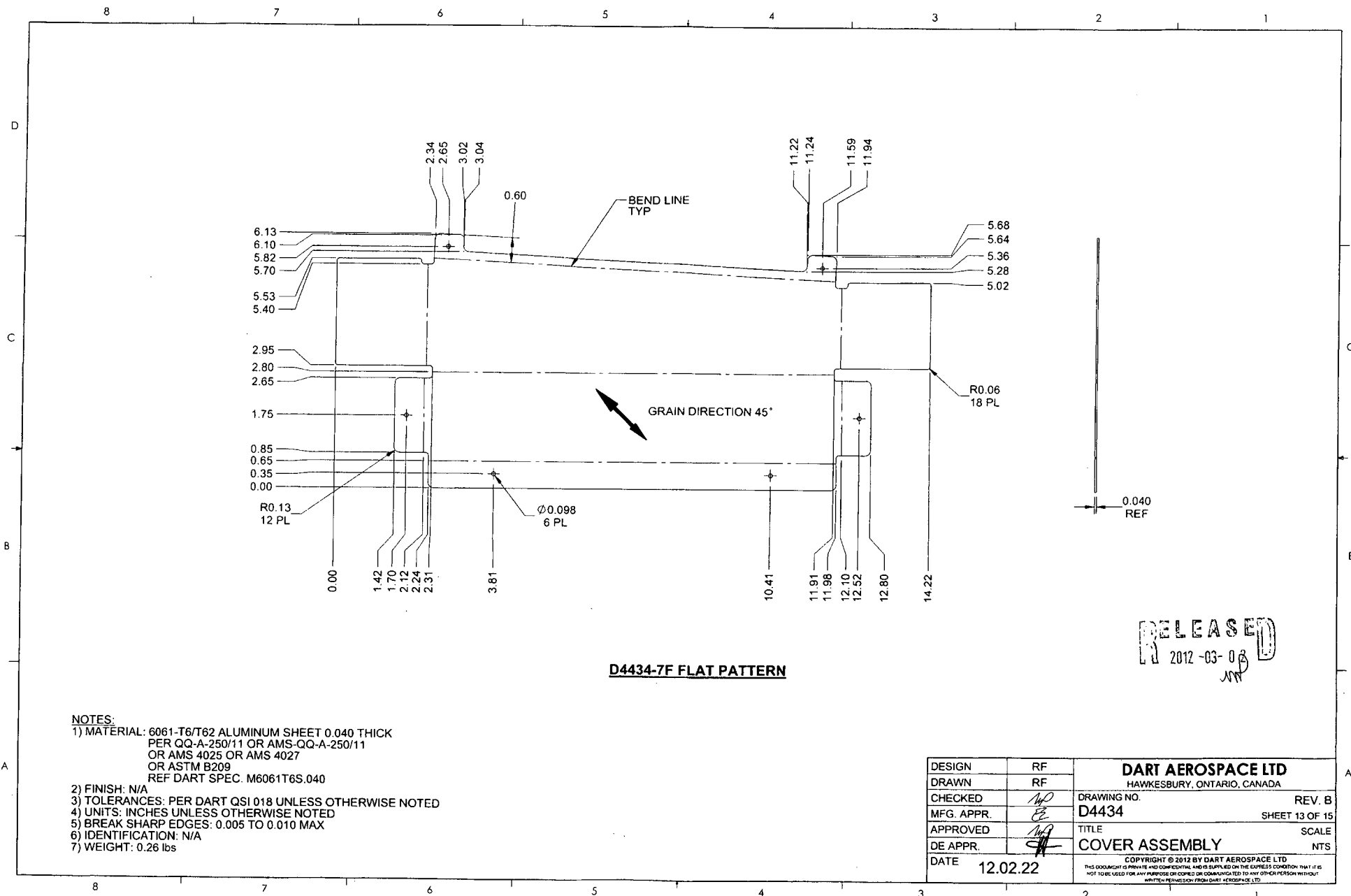
# **D4434-7 BRACKET**

## **NOTES:**

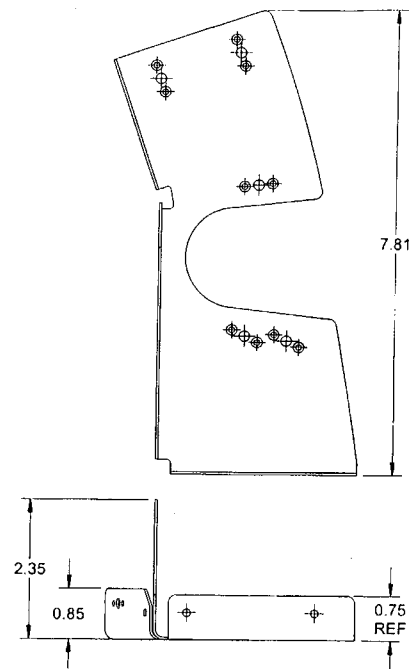
- 1) MATERIAL: MAKE FROM D4434-7F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.26 lbs
- 8) TRANSFER Ø0.129 HOLE THRU 2 PLACES

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2012-03-02  
ND

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DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	<b>D4434</b>	SHEET 12 OF 15
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	<b>COVER ASSEMBLY</b>	NTS
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 2012-03-08  
*MD*



R0.13  
TYP

0.75  
2 PL



**D4434-9 BRACKET**

**NOTES:**

- 1) MATERIAL: MAKE FROM D4434-9F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs

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2012-03-02  
AW

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	MP	DRAWING NO. <b>D4434</b>	REV. B
MFG. APPR.	BE	SHEET 14 OF 15	
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	<b>COVER ASSEMBLY</b>	NTS
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